

split

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	22252
<b>Description:</b> Pin Assembly		<b>Part Number:</b>	D3332-043
<b>Dwg:</b> D3332 Rev. A PAGE 1, 3, 4		<b>Qty:</b>	10 9
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.01.17	10
2	MC	Machine D3332-7 as per Folio FA493 and Dwg D3332 Material: AISI 1018-1025 Ø0.500" Round Bar (M1018-R0.500) <b>Identify for D3332-7</b> Batch: M16210	mf	05.02.10	10
3	QC2	Inspect parts as they come off the CNC machine <b>Identify as D3332-7</b>	mf	05.02.10	10
4	QC8	Second check	BE	05.02.02	10
5	MFA	Fabricate D3332-9 as per Dwg D3332 Material: AISI 1018-1025 Ø0.313" Round Bar (M1018-R0.313) <b>Identify as D3332-9</b> Batch: M16634	CPL	05-02-02	10
6	MFA	Assemble and Weld using D3332-041T1 as per Dwg D3332 <b>Pick:</b> Qty Part Number Description Batch 1 D3332-1 Handle 22268 A/R N/A Steel Rod M93826 <b>Identify as D3332-043</b>	CPL	05-02-15	2 9
7	QC5	Inspect work to Step 6	mf	05.02.15	9
8	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <del>Cover D3332-7 and cover thread only for D3332-9 prior to painting</del>	mf	05.02.17	9
9	QC3	Inspect Powder Coat	u	05.02.18	9
10	ST	Identify and Stock	u	05.02.18	9
11	AC	Cost / part: 28.37	Syc	05.02.21	9
12	DC	Close W/O 28.37 Inspect Level 21	JA	05.02.23	9

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED  
05/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

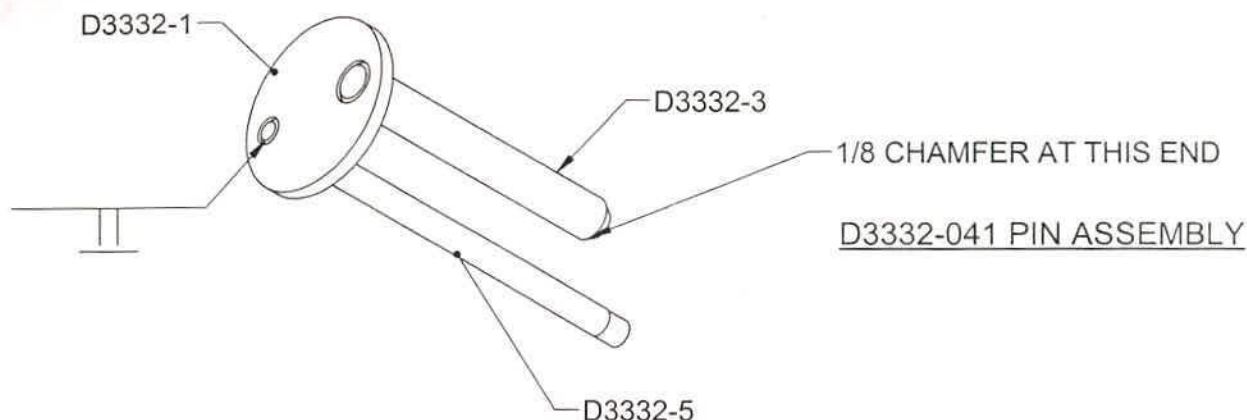




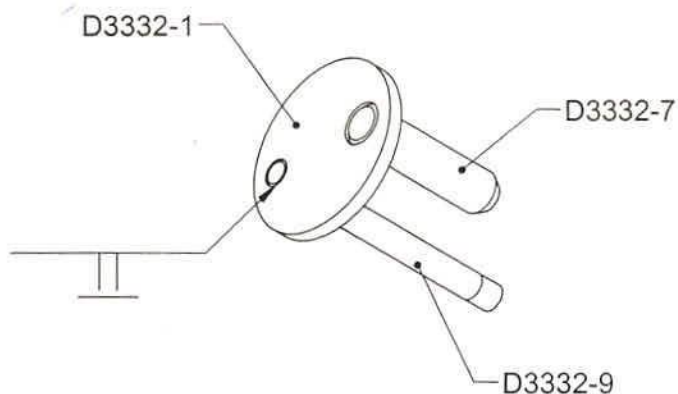




DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RT</i>	APPROVED	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	



D3332-041 PIN ASSEMBLY



D3332-043 PIN ASSEMBLY

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.10

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 2252

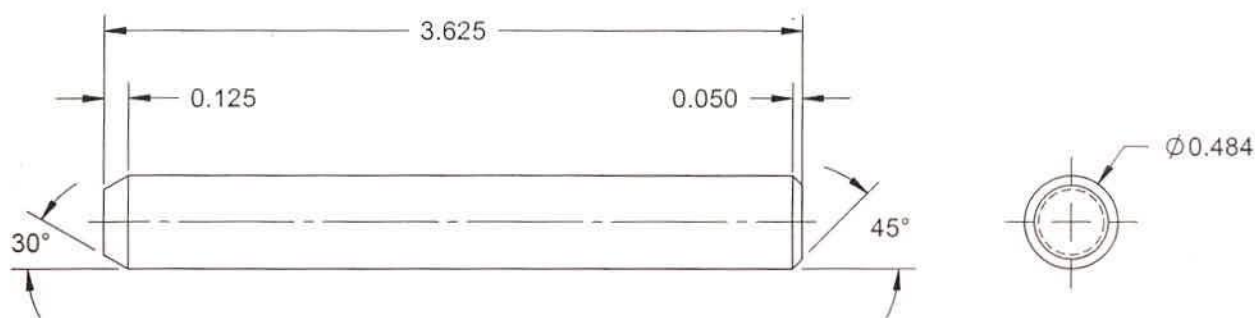
**PRELIMINARY ISSUE**

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

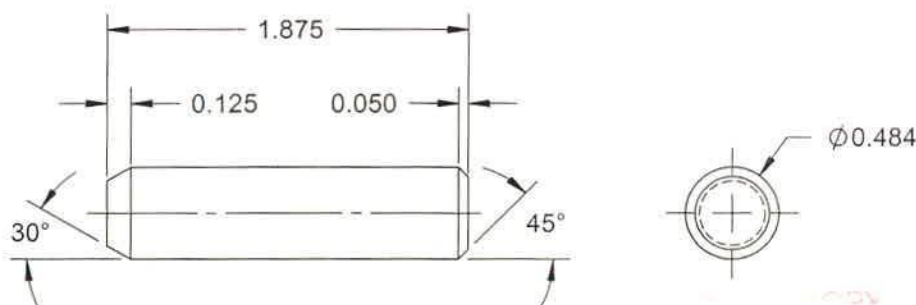
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3332	REV. A SHEET 3 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN



3332-7 PIN

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**PRELIMINARY ISSUE**

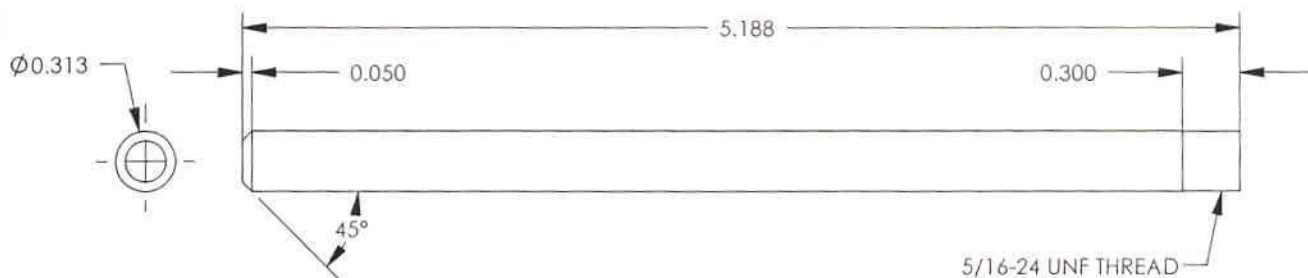
COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

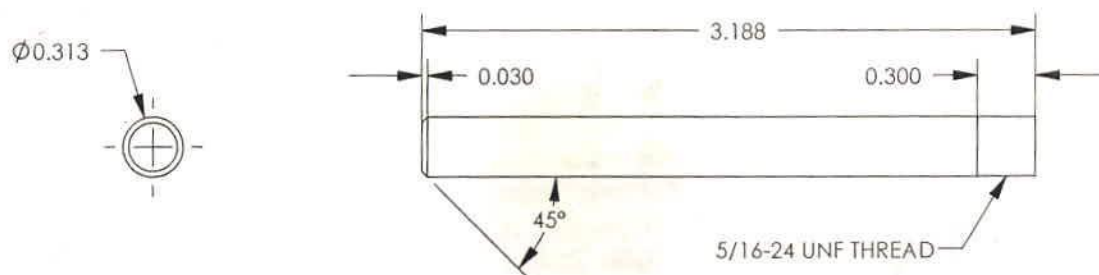




DESIGN <i>AS</i>	DRAWN BY <i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED	DRAWING NO. D3332	REV. A SHEET 4 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



D3332-5 SHAFT



D3332-9 SHAFT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 72252

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

**PRELIMINARY ISSUE**

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 17, 2005  
01:31 pm

Work Order No : 0022252  
Project Name : D3332-043  
Project For :  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3332-043  
Description : Pin Assembly  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 01-17-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Margin : 0.000%  
Actual Margin : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00